



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3915-041
Job Sheet 214509



Part No: D3915-041

Job Qty: 1 pcs

Part Name: Light Lid Assembly, Long Basket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/20

Job Tracking No:

Due Date: 12/1/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 13.07.08 as per dwg rev.D DD verf:JLM IPP REV:D 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs			0.00	4.50	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs			0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
120	QC 5	1 pcs			0.00	0.00	QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		

CC NOV 9, 2020

NOV 11 2020

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Container No: S311855



Part: D3915-041

Job No: 214509

Serial No/Batch: S311855

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/10/20

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			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
			Handfinish - 1 - 1 - B4B	all 20-11-16
			Handfinish - 1 - 2 - B4B	
130 Handfinish - 1-1 Chemical-B4B	1 pcs	0.00 1.00	Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
140 Large Fab - Welded Assy-2-B4B	1 pcs	0.00 3.33	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	DAS 24
			Large Fab - 3 - B4B	9-89
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
150 QC 9	1 pcs	0.00 0.00	QC 9 - 10	
			QC 9 - 18	
			QC 9 - 24	
			QC 9 - 43	
			QC 9 - 50	DAS 50
			QC 9 - 9	11-18-20
				9-89
155 QC 5	1 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	

			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	DAS
			QC 5 - 50	50 1-18-20
			QC 5 - 30	9-89
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
157 Handfinish - 1-2- Chemical-B4B	1 pcs	0.00 1.00	Handfinish - 1 - 1 - B4B	20-11-17
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White Gl(A)-B4B	1 pcs	0.00 0.83	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	20-11-19
			Powdercoat - 4 - B4B	
			Powdercoat - 5 - B4B	
			Powdercoat - 6 - B4B	
			Powdercoat - 7 - B4B	
			Powdercoat - 8 - B4B	
			Powdercoat - 9 - B4B	
			Powdercoat - 10 - B4B	
170 QC 3	1 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	20-11-19
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	

			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
			QC 3 - 87	
			QC 3 - 47	
180 Handfinish - 4-1-Assembly-B4B	1 pcs	0.00 0.81	Handfinish - 4 - 1 - B4B	Jul 20-11-19
			Handfinish - 4 - 10 - B4B	
			Handfinish - 4 - 11 - B4B	
			Handfinish - 4 - 12 - B4B	
			Handfinish - 4 - 13 - B4B	
			Handfinish - 4 - 14 - B4B	
			Handfinish - 4 - 15 - B4B	
			Handfinish - 4 - 2 - B4B	
			Handfinish - 4 - 3 - B4B	
			Handfinish - 4 - 4 - B4B	
			Handfinish - 4 - 5 - B4B	
			Handfinish - 4 - 6 - B4B	
			Handfinish - 4 - 7 - B4B	
			Handfinish - 4 - 8 - B4B	
			Handfinish - 4 - 9 - B4B	
190 QC 5	1 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	NOV 19 2020 40
			QC 5 - 61	9-89
			QC 5 - 81	
			QC 5 - 82	
200 Packaging 3-1 - Stock - B4B	1 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	

			Packaging 3 - 15 - B4B	20-11-17
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	
210 QC 21 - SA	1 pcs	0.00 0.00	QC 21 - SA - 21	DAS
			QC 21 - SA - 70	21
			QC 21 - SA - 9	3-89
			QC 21 - SA - 77	
			QC 21 - SA - 28	NOV 19 2020

Part Op 100 - (Weld per dwg A/R Aluminum rod Batch: 139089 assemble ribs, weld as per dwg D3915 using DT9606A. When Descriptions: welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld. ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME**** 2- weld hinge, label plate and Mounting plates as per dwg D3915

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O) -Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4

130 - (Chemical Conversion Coat per QSI005 4.1) ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE***

140 - (Weld per dwg A/R Aluminum rod Batch: 139089 weld (4) corners

150 - (QC9- Inspect visual per QSI004- Fusion Welds)

155 - (QC5- Inspect part completeness to step on W/O) ***inspect fit of lid with base***

157 - (Chemical Conversion Coat per QSI005 4.1) 1- realodine corners ***do not acid etch***

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) 1- touch up corner with alodine only 2- Plug holes prior to finish 3-

Mask this area prior to finish View B-B 1ST COAT: START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____ 2nd coat if necessary ***** 2ND COAT: START TIME: _____

170 - (QC3- Inspect Part Finish) OVEN TEMPERATURE: 300° FINISH TIME: 11:20 - 17254469

180 - (Assemble as per dwg) 1- Install webbing as per dwg 2- Install placard and label as per dwg

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____)

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2957	Mounting Plate	4 pcs (4 ea)	100-Large Fab - Welded Assy-1	5083647
D3915-1	Rib	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5184742
D4016-5	Hinge Half, Light Lid	3 pcs (3 ea)	100-Large Fab - Welded Assy-1	5039258
D4019-3	Rib	3 pcs (3 ea)	100-Large Fab - Welded Assy-1	5311085
D4035-047	Lid Rib Assembly, Aft (Light)	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5311180
D4056-1	Label Plate	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5067108
D4029-041	Webbing (Long Basket)	1 pcs (1 ea)	180-Handfinish - 4-1-Assembly-B4B	5164049
MS20600-AD4W4	Rivet	34 Ea (34 ea)	180-Handfinish - 4-1-Assembly-B4B	5231821
NAS1149DN949J	Washer	34 Ea (34 ea)	180-Handfinish - 4-1-Assembly-B4B	5262011

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2957	4	17	0
	D3915-1	2	8	0
	D4016-5	3	46	0
	D4019-3	3	4	0
	D4035-047	2	0	0
	D4056-1	1	7	0
	D4029-041	1	7	0
180-Handfinish - 4-1-Assembly-B4B	MS20600-AD4W4	34	558	0
	NAS1149DN949J	34	142	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					